Tuesday, 4/17/2007 3:56:14 PM

Kim Johnston User:

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Estimate Number

Job Number : 31921

P.O. Number

: 11104

This Issue

: N/A

Prsht Rev.

: 4/17/2007

: NC

: MA First Issue

Previous Run

: 27737

: SMALL /MED FAB

S.O. No. : NIA

Drawing Name

: DECK PLATE, FWD ,350 LITTER KIT

Part Number

: D2364

Drawing Number

· D2364 REV.F : N/A

Project Number **Drawing Revision**

: F 4

Material

: NA

Due Date

: 5/2/2007

Qty:

10 Um:

Each

Checked & Approved By

Comment

Written By

: EST. REV. E

00.06.26

Removed P/O for powder coat EC

Now On Waterjet 06-07-03 JLM Est Rev:F

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

2024-T3 .063 sheet

1.0

M2024T3S063

6.7925 sf(s)

2024-T3 .063 Aluminum sheet

(M2024T3S063)

Comment: Qtv.:

0.6792 sf(s)/Unit Total:

Comment: FLOW WATER JET

1-Cut as per Dwg D2364

Dwg Rev:_ Prog Rev:___

2-Deburr if necessary

3.0

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(1)

Comment: SECOND CHECK



5.0

HAND FINISHING1

SECOND CHECK



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1





Dart	Aerospa	ce Ltd

W/O:		74	WORK ORDE	R CHANGES				
DATE	STEP	27	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						k ÷		· .
						,# *		
						7	200	

Part No: _	PAR #:	Fault Category:	NCR: Yes Mo	DQA:	Date: 07/05/28
			QA: N/C C	osed:	Date:

NCR:	·	V	VORK ORDE	ER NON-CONFORMAN	CE (NCR)	· .		
		Description of NC		Corrective Action Section I	3	Verification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC inspecto
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NOTE: Date & initial all entries

Tuesday, 4/17/2007 3:56:14 PM Date: : User: Kim Johnston **Process Sheet** Drawing Name: DECK PLATE, FWD , 350 LITTER KIT Customer: CU-DAR001 Dart Helicopters Services Job Number: 31921 Part Number: D2364 Job Number: Seq. #: Description: **Machine Or Operation:** POWDER COATING POWDER COATING M102316 Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE U 95 28 Job Completion

Dart Ae	rospac	e Lta								
W/O:			WC	RK ORDER CHANG	ES		,			
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			,							
Part No	:	PAR #:	Fault Cate	jory:	NCR:	Yes	No DQA	\:	Date:	
						QA: N	C Closed	l:	_ Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE	NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description		Sign &	Verific		Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Section	in C	Chief Eng	QC Inspector
					And the second					

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31921
Description: Litter Deck Plate Kit (350)	Part Number:	D2364
Inspection Dwg: D2364 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	le] Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6,628	1		Vern	
Ø0.171	+0.005/-0.000	80,173.	V		Vern	
0.354	+/-0.010	0.354	~		Vern	
11.242	+/-0.010	11,250	J	,	vern	
3.031	+/-0.010	3.034	V		Vern	
1.903	+/-0.010	1.9099	1/	7	Vern	
1.128	+/-0.010	1,131 .	ب		Vern	
0.354	+/-0.010	0.355			Vern	
1.340	+/-0.005	1, 345	\sim		vern	
2.326	+/-0.010	2,330			()ern	
3.312	+/-0.010	3.316			Vern	
4.298	+/-0.010	4,298	1		neight gauge	.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,
5.284	+/-0.010	5,283	/		height says	
6.151	+/-0.010	6,153	<i>\(\)</i>		height sauge	
6.270	+/-0.010	6.268			height going	
0.354	+/-0.010	0.363	/		Jernja	
3.031	+/-0.010	103 034			neight anone	
Ø0.656	+0.005/-0.000	00.656			Vern	
5.003	+/-0.010	5.007	/		height quoce	
4.605	+/-0.010	4,609.			height gause	
1.776	+/-0.010	1,774		1-1-	neight agus	
0.980	+/-0.010	0.982			11	
4.487	+/-0.010	4,490			height sauce height gage	
7.192	+/-0.010	7.187			height acigle	
7.87.567	+/-0.010	7,561			height says-	16
7.942	+/-0.010	7,937	V		height shuge	
Ø0.191	+0.005/-0.000	Ø0.791 V	V		Vern	
Ø0.197	+0.005/-0.000	\$0.190	/		Vern	
11.145	+/-0.010	11,152	/		Height source	
12.181	+/-0.010	12 190 .	1		Height come	
11.378	+/-0.010	11,375.	J,		height carib	
11.776	+/-0.010	11,780	\mathcal{O}_{i}		heir ht chil	
12.173	+/-0.010	12.177			neight chile	
4.690	+/-0.010	4.692			neight game	
0.250	+0.005/-0.000	0.249	./		Devin	
3.141	+/-0.010	3.146.			height cauce	
€ 0.17 10,128	+0.005/-0.00	0.130)	Vem	E
Measured by:	SAD	Audited by:			Prototype Approval	: N/A

Date: Date: Date: N/A Revised by Change Rev Date 04.06.25 New Issue P/O D350-616-015

E

COUNTER SINK HOLES:

C'SINK Ø0.225 x 100' (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.DI TO CORRECT CAD ERROR)

C'SINK Ø0.308 x 100'

•





3.031	R0.354 (TYP)	13.04
8 9 1	6 -	6.624
6.270 \$0.656	RO.328 (TYP) — + -	6.270
6.151 + 5.753		<u>,</u> 7 /
5.284 + RO.125		5.284
R0.125 R0.125	7 2 3	•
4.298 + 1 8 - 4.605	4.292 — (+)	1
1.37	#0.191 R0.125	1
3.312	60.250	。 /
	\$ - \square 60.197 (2)	
2.326 — •	Z.200 ← R0.125 ⊕ − Z.200	#0.171 (TYP)
1.750	+ • • • • • • • • • • • • • • • • • • •	- 1
1.340	70 RO.625	- 1
	6	- 1
0.354	-	0.354
0.000		0.000
1.128	9.948	12,480
#0.128 (TYP)	-	•

MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THI
可

DESIGN PRAWN BY HAWKESBURY, ONTARIO, CANADA CHECKED APPROVED DRAWING NO. D2364 PATE TITLE 98.06.19 A 95.01.14 NEW ISSUE B 95.02.09 MOVED KEYWAY D 95.03.06 GEOMETRY CHANGES DART AEROSPACE LTD REV. F SCALE SCAL
DRAWING NO. PROPRIED ORAWING NO. D2364 TITLE LITTER DECK PLATE, 350 95.01.14 NEW ISSUE 95.02.09 MOVED KEYWAY 95.03.06 0.191 WAS 0.197 95.10.06 GEOMETRY CHANGES 0.063-0.071 THICK WAS 0.07
DART AEROSPACE (PRAWING NO. D2364 TITLE LITTER DECK PLATE, 350 14 NEW ISSUE NEW ISSUE 0.06 0.191 WAS 0.197 0.06 GEOMETRY CHANGES 0.063-0.071 THICK WAS 0.07
DART AEROSPACE (HAWKESBURY, ONTARIO, CANADA ORAWING NO. D2364 TITLE LITTER DECK PLATE, 350 NEW ISSUE MOVED KEYWAY 0.191 WAS 0.197 GEOMETRY CHANGES 0.063-0.071 THICK WAS 0.07